

Work Order ID 50181

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July 10, 2009 8:56:26 AM

Item ID: D2221

Accept



Setup

Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D2221	Rev H

100



Large Fab

0.00

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221-2-
remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221-3- tack weld mesh on basket as per dwg D2221 A/R ER316
S.S. Rod Batch: M108160

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

120



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Work Order ID 50181

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Start Date: 7/14/09 Start Qty: 1.00

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Accept



Setup Start



Stop



Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Pressure Wash

Memo M112448.

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

UMD 09/07/20 (X)

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

→ S018701



Memo

0.00

Identify & Stock _____

50187 HJ

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/23 HJ

MF
09-07-23

Picklist Print

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Work Order ID: 50181



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	14.0000	1.0000			

Rib

Warehouse

Location

Main Warehouse

ST	14
48101	1
48318	5
48427	8

1 PD 09.07.15

D2221-5RevH



Manufactured

No

100

Each

4.0000 2.0000



Rib

Warehouse

Location

Main Warehouse

ST	4
48390	4
500260	100

1 PD 09.07.15

D2221-7RevH



Manufactured

No

100

Each

6.0000 1.0000



Rib

Warehouse

Location

Main Warehouse

ST	6
48201	2
48450	4

1 PD 09.07.15

Picklist Print

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Work Order ID: 50181



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	15.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST 15

47263 3

48443 12

2 PD 09.07.15

D2235-1RevB1

Manufactured

No

100

Each

17.0000 2.0000

Basket Rib

Warehouse

Location

Main Warehouse

ST 17

48665 7

50029 10

2 PD 09.07.15

D2581RevA1

Manufactured

No

100

Each

35.0000 2.0000

Mounting Bracket

Warehouse

Location

Main Warehouse

ST 35

46086 2

48428 33

2 PD 09.07.16

Picklist Print

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Work Order ID: 50181



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	22.0000	2.0000			

Shim

Warehouse

Location

Main Warehouse

ST	22
46767	1
47074	9
50023	12

2 PD 09-07-16

D3825-041RevA

Manufactured

No

100

Each

8.0000

2.0000

Rib Assembly (Basket End)

Warehouse

Location

Main Warehouse

ST	8
48430	2
48668	6

2 PD 09-07-15

D3826-041RevB

Manufactured

No

100

Each

4.0000

2.0000

Rib / Gusset Assembly

Warehouse

Location

Main Warehouse

ST	4
48644	4
50028	2

PD 09-07-15

Picklist Print

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Work Order ID: 50181



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/14/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	7.0000	1.0000			

Rib Assembly (Inboard)

		<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		<u>Location</u>			
		Main Warehouse			
		ST	7		
		48100	1		
		48454	6		

Mesh (Base)

D3832-1RevA	Manufactured	No	100	Each	2.0000	1.0000	
-------------	--------------	----	-----	------	--------	--------	--

Mesh (Base End Face)

D3833-1RevA	Manufactured	No	100	Each	7.0000	2.0000	
-------------	--------------	----	-----	------	--------	--------	--

		<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		<u>Location</u>			
		Main Warehouse			
		ST	2		
		48645	1		
		46306	1		
		46774	1		

1 PD 09.07.15

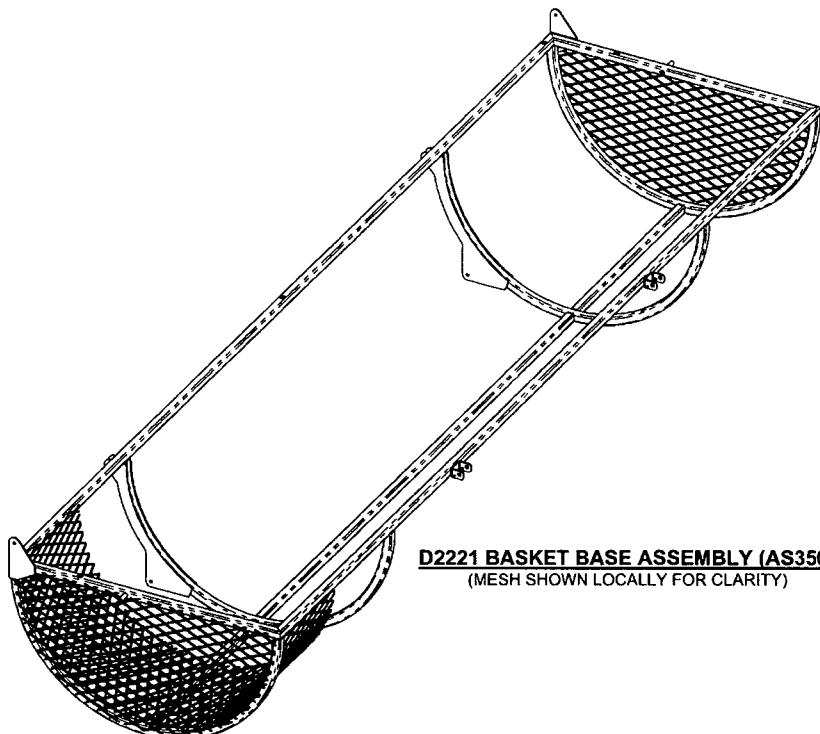
		<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		<u>Location</u>			
		Main Warehouse			
		ST	2		
		48645	1		
		46306	1		
		46774	1		

D3833-1RevA	Manufactured	No	100	Each	7.0000	2.0000	
-------------	--------------	----	-----	------	--------	--------	--

		<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		<u>Location</u>			
		Main Warehouse			
		ST	7		
		46665	1		
		48646	6		

2 PD 09.07.16

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

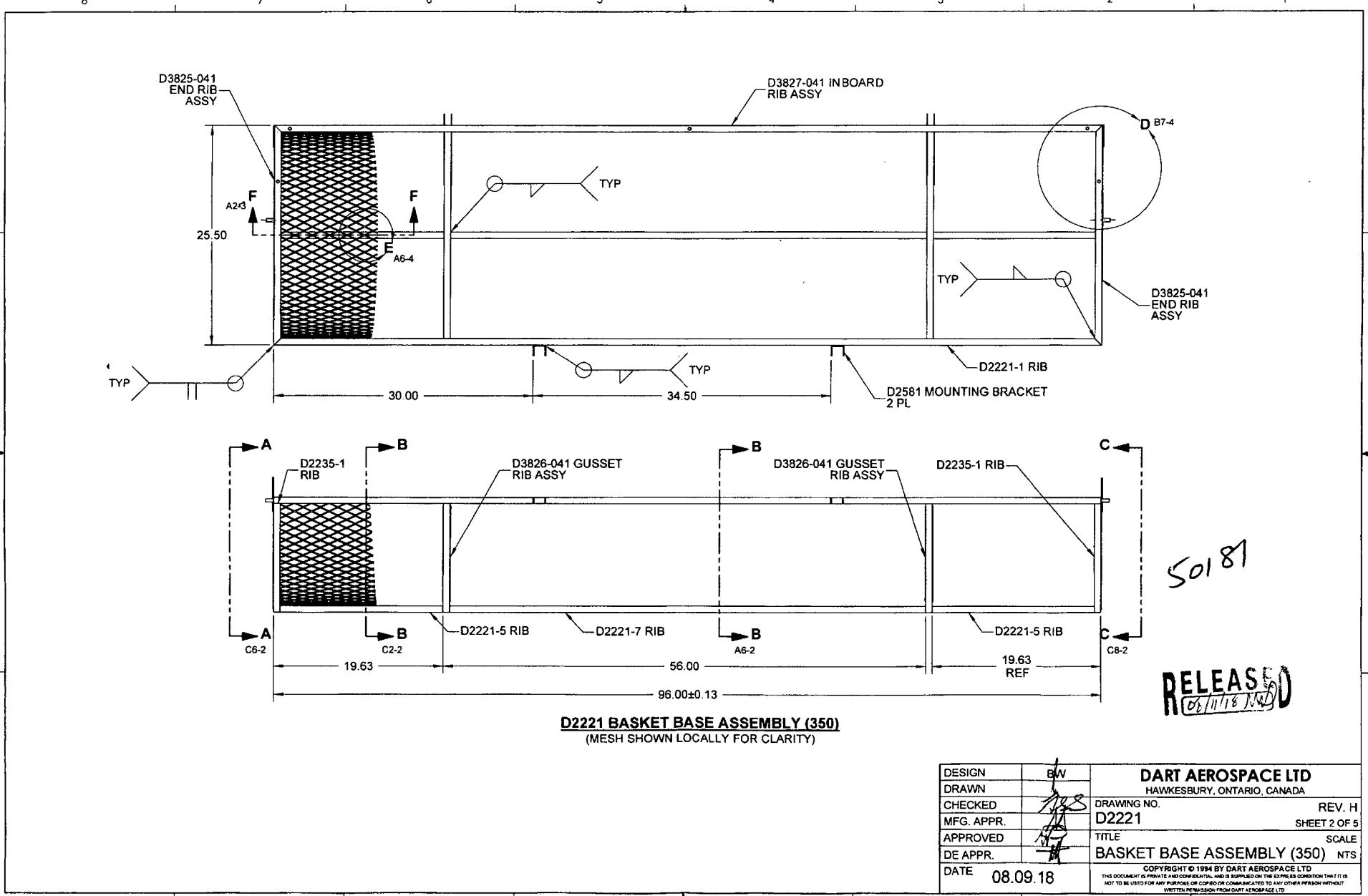


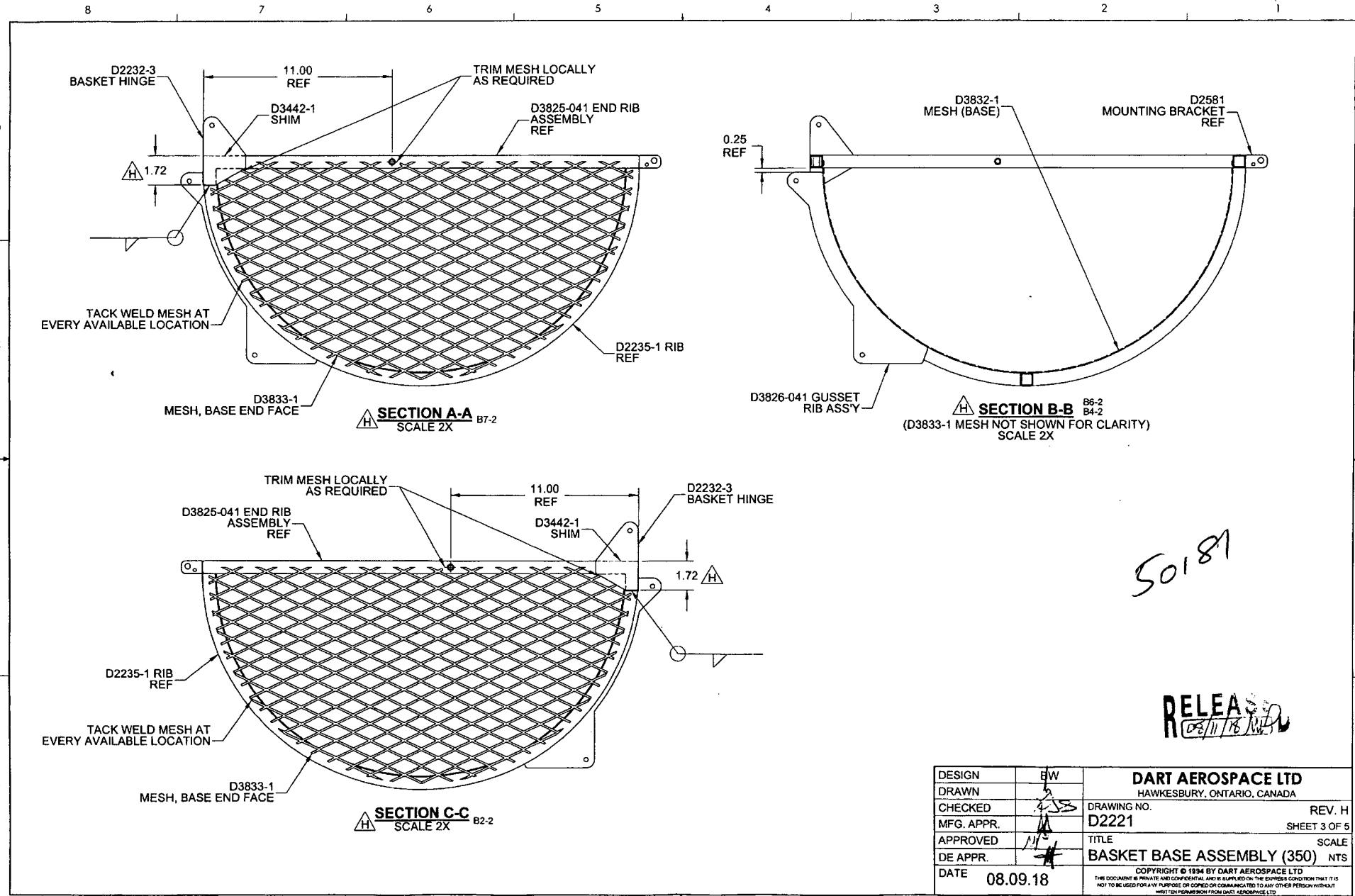
W/0 SOL81

NOTES:

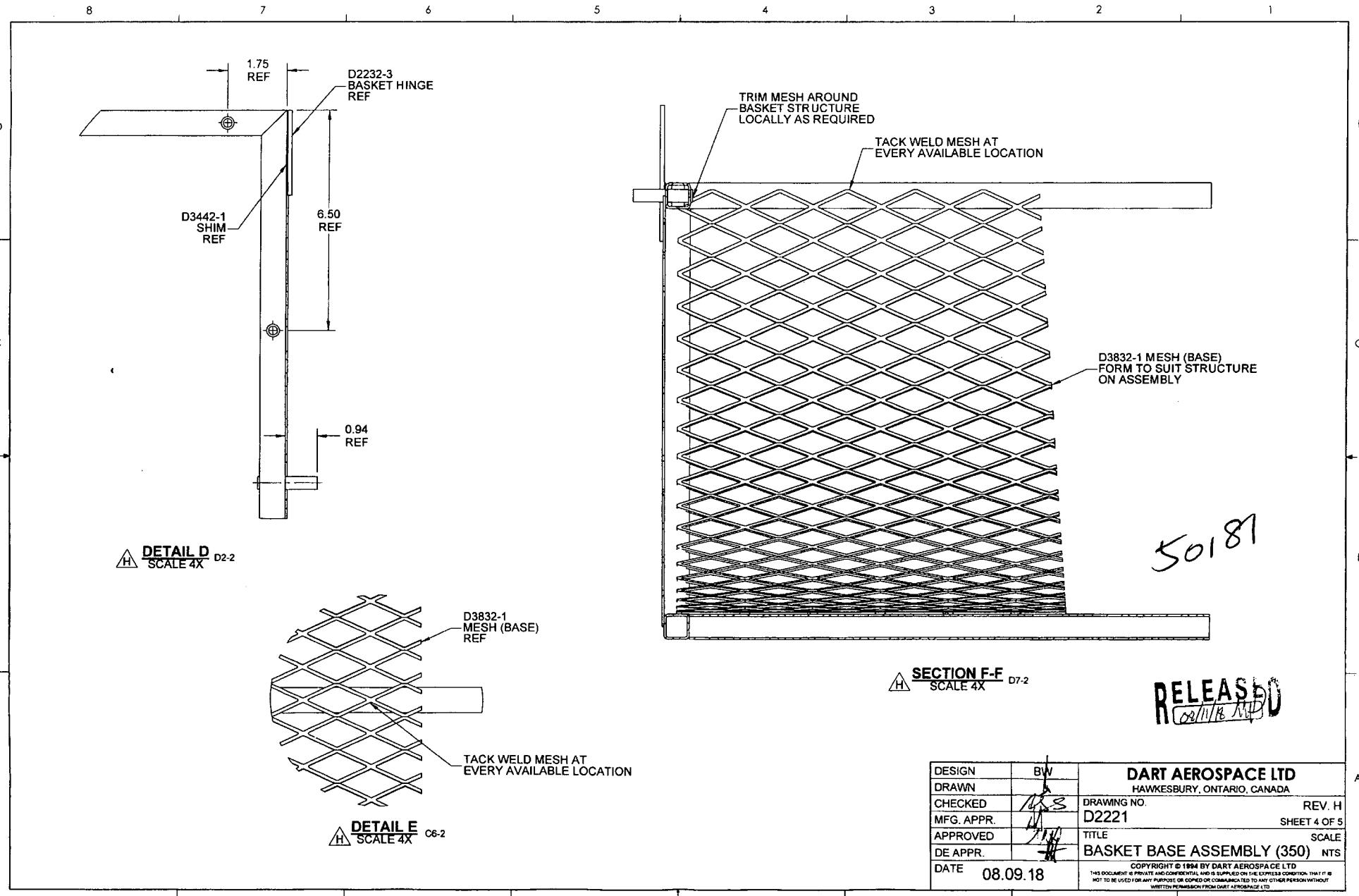
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D3227-3; D3826-041 REPLACES D2221-1/5-7; D3827-041 REPLACES D2221 ONBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS +/-0.02 (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW FREE (ZN B5-2); 19.62 DIM WAS TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	WSS	DRAWING NO. REV. H	
MFG. APPR.		D2221 SHEET 1 OF 5	
APPROVED		TITLE SCALE	
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THOSE COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

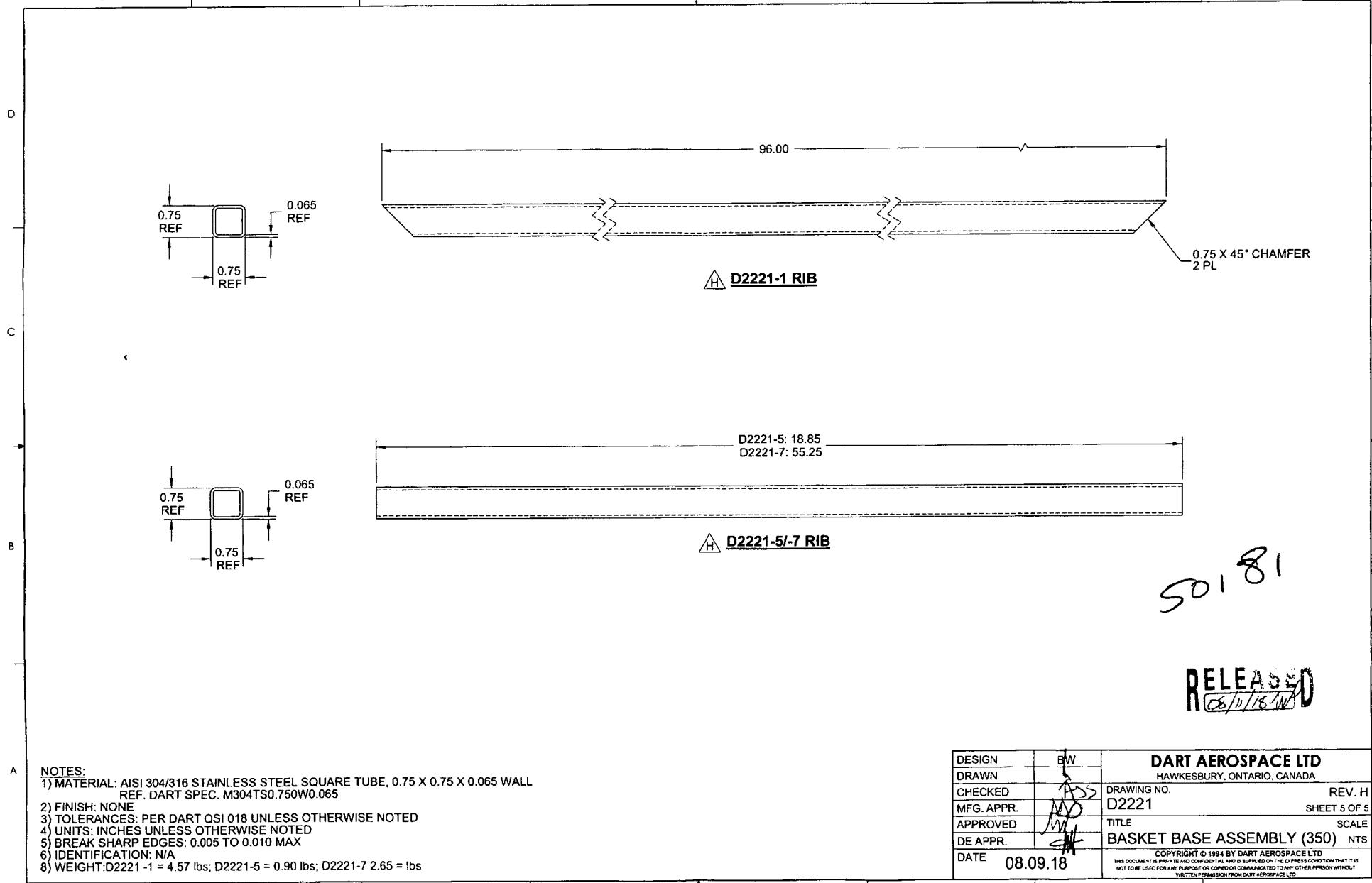




DESIGN	EW	DART AEROSPACE LTD
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	DRAWING NO.
MFG. APPR.	<i>✓</i>	D2221
APPROVED	<i>✓</i>	REV. H
DE APPR.	<i>✓</i>	SHEET 3 OF 5
DATE	08.09.18	TITLE
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8 7 6 5 4 3 2 1



DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. H
MFG. APPR.	NO	D2221 SHEET 5 OF 5
APPROVED	W	TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS
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